

Aux 412

Work Order ID 125505

125505

Thursday, October 09, 2014 2:19:13 PM

Item ID: 41228-502-016-003 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Plate and Spacer
 Start Date: 10/9/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/9/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-10-09 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
41228-502-016	E2								
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>st50</u>	0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging									

FEB 11 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125505***125505***

Page 2

Thursday, October 09, 2014 2:19:13 PM

Item ID: 41228-502-016-003

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mounting Plate and Spacer

Start Date: 10/9/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/9/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

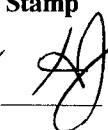
140

QC

Memo

0.00

Quality Control

15/2/18  S-2-18

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
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Material									
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Offset/Setup									
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Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, October 09, 2014 2:19:17 PM

Page 1

Work Order ID: 125505

125505

Parent Item: 41228-502-016-003

41228-502-016-003

Parent Item Name: Mounting Plate and Spacer

Start Date: 10/9/2014

Required Date: 10/9/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.10.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-4		Purchased	No				Each	4,028.000		8			
MS20426AD3-4									**		FF	FEB 11 2015	
RIVET													

Location	Loc Qty	Loc Code
ST315	4028	
125578	2078	
m127432	1950	

MS21061LO8K		Purchased	No				Each	12.0000		4			
MS21061LO8K									**		FF	FEB 11 2015	
NUT PLATE													

Location	Loc Qty	Loc Code
CA	12	
m129590	12	

41228-502-016-005		Manufactured	No				Each	3.0000		1			
41228-502-016-005									**		FF	FEB 11 2015	
Spacer Plate													

Location	Loc Qty	Loc Code
CA	3	
m129682	3	

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Training									
Transport									
Unapproved									

FAULT CATEGORY

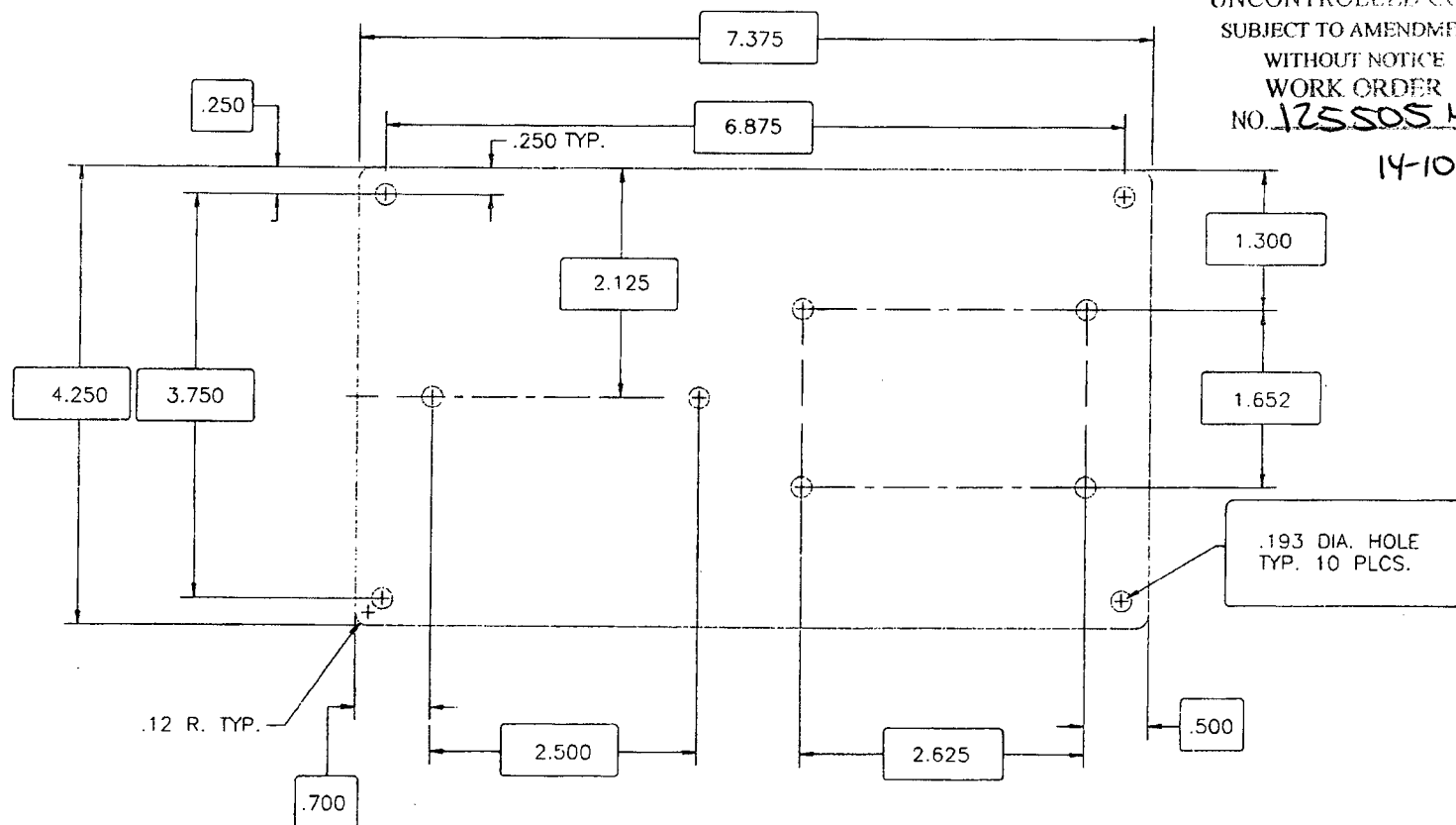
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.		03894		SHEET 1 OF 1	
DWG NO.	41228-502-016	REV:	E	PREPARED BY	J. BAINI
DATE:		05/28/13		EFFECT ON DWG ☐ INC. ☒ UNINC.	
DWG TITLE: MOUNTING PLATE & SPACER					
APPROVED BY:	ENGR <i>[Signature]</i>	MFG	<i>[Signature]</i>	QC	<i>[Signature]</i>
REASON:		ADDED INSPECTION DIMENSIONS		EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		ECR:			

SHEET 1, ZONE B4, IS:

CONTROL COPY
ISSUED DATE
JUN 10 2013



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125505 MWS
14-10-09

DOCUMENTS EFFECTED:

☐ RFMS ☐ MDL ☐ INSTALL INSTRU

☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03196

SHEET 1 OF 1

DWG NO. 41228-502-016

REV: E

PREPARED BY

J. GARDINER

DATE: 08/16/11

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: MOUNTING PLATE & SPACER

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

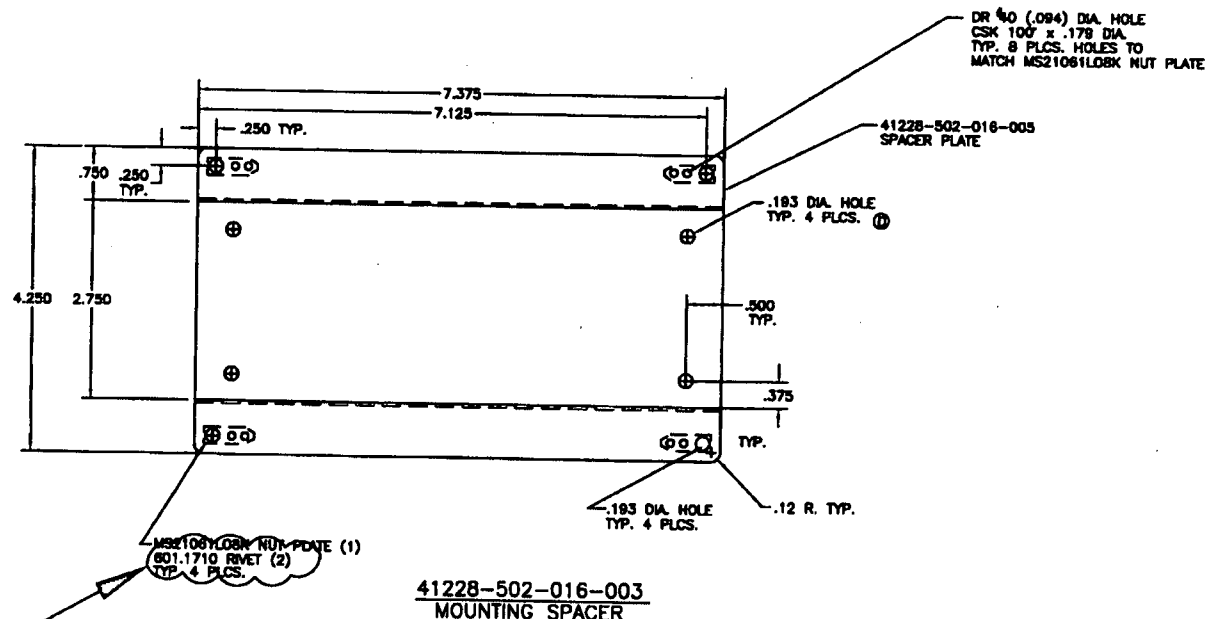
[Signature]

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISE F/N 2 FROM MS20426AD3 TO 601.1710



IS

SHEET 2, ZONE C2 IS:

2	R	601.1710	8		RIVET	MS20426AD3-4	
F/N	TC	PART NUMBER	-003	-001	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY				
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
						☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☒ BOM	☐ MAJOR ☒ MINOR
							☐ YES ☒ NO

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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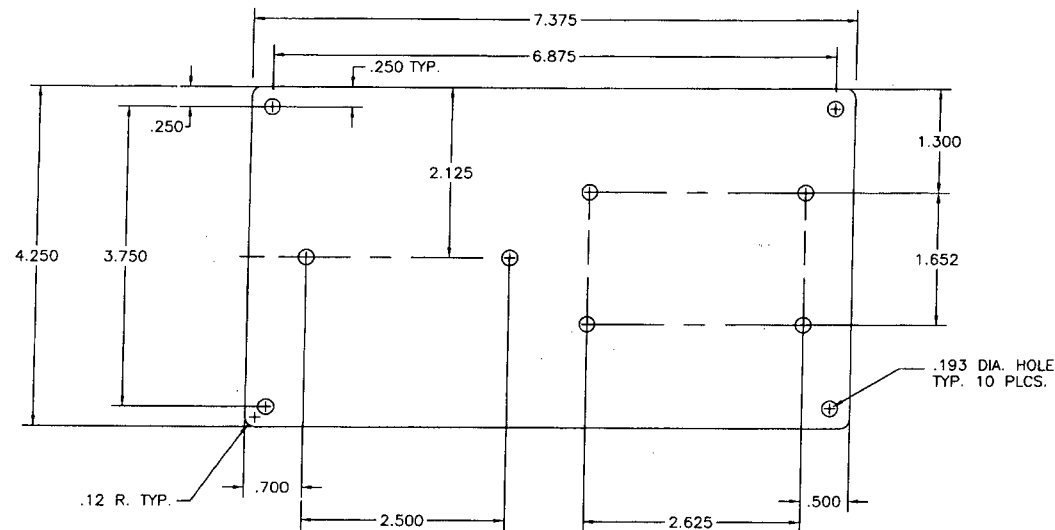
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APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	REVISED NOTE 1 ON FINISH SPEC.	09-20-93	
B	GENERAL UPDATE	10-11-93	
C	ADDED -003 SPACER TO F/D & L/W REVISED NOTE 1 ADDED NOTE 2	12-27-93	
D	CHANGED STOCK SIZE ON -003 SPACER. ADDED 4 EA 193 DIA. NILES ON -003 SPACER.	04-18-94	
E	INCORPORATED ECH 03068	02-08-11	P. BRADY

**UNINCORPORATED ECN(s)**

031916, 03894

41228-502-016-001
MOUNTING PLATE

			1	3	41228-502-016-005	SPACER PLATE		A	AA
			4	2	MS20426AD3	RIVET			
			4	1	MS21061L08K	NUT PLATE			
			X		41228-502-016-003	SPACER			
				X	41228-502-016-001	PLATE		A	AA
			-003	-001	FIND NO.	PART No.	DESCRIPTION	MAT'L	SPEC
QTY REQ'D					PARTS LIST				
NEXT ASSY(S)					ORIGINAL DATE (DD-MM-YY) 06-13-93 DRAWN BY CHECKED T. MARVELLE DRAFTING APPROVAL CONTRACT No. UNDER OTHERS SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: 3 PLACE DECIMALS ± .001 2 PLACE DECIMALS ± .005 ANGLES ± .000				
41228-502-017					 NEW BRIDGE PLATE & SPACER CO. 1000 W. 10TH ST. CHICAGO, ILL. 60607-4000				
					MOUNTING PLATE & SPACER				
					SIZE CASE CODE DWG. No. REV B 07M26 41228-502-016 E SCALE FULL 1 SHEET 1 OF 2				

3 MATERIAL: 2024-T3 QQ-A-250/5.

2 PAINT FLAT BLACK WITH MIL-C-46168 PAINT USING FED. STD.
595B COLOR No. 37038.

① CHEMICAL CONVERSION COATING PER MIL-C-5541E CLASS 1A.

NOTES:

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Work Order update only ☐

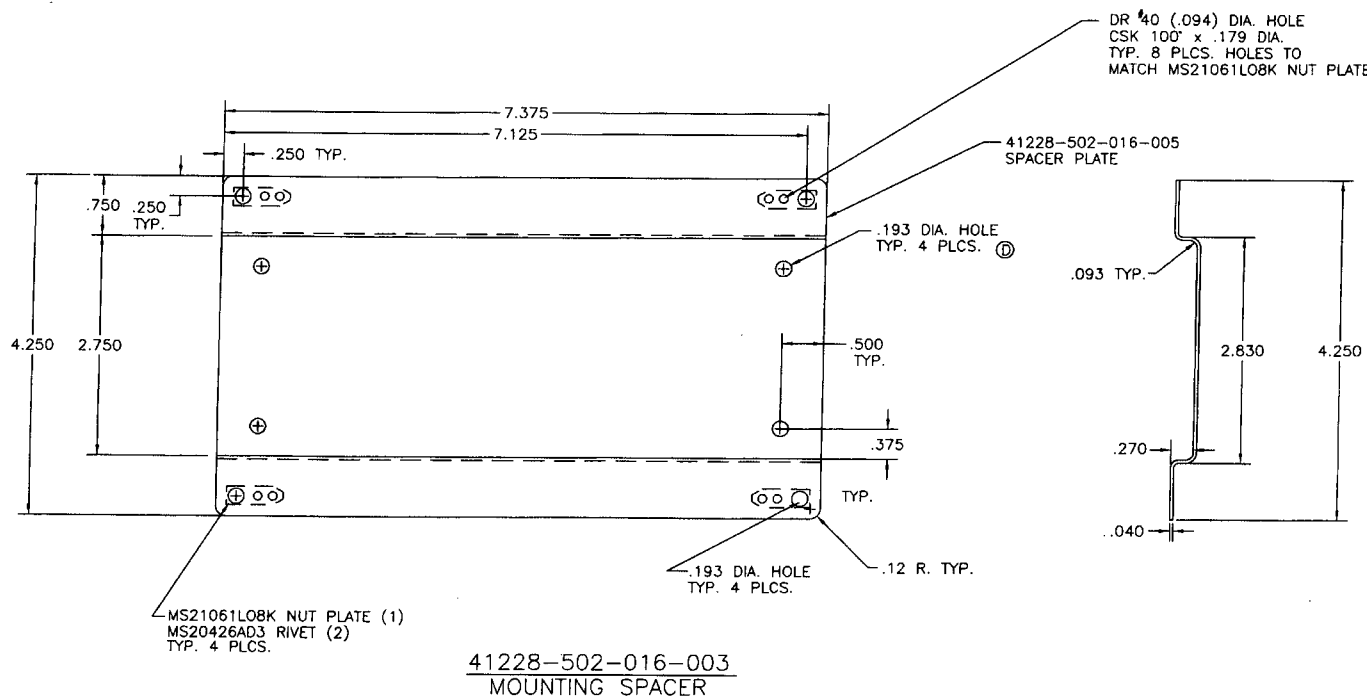
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ORIGINAL DATE 08-13-93		 APICAL INDUSTRIES, INC.	
DESIGNED BY T. HARVILLE			
DRAWING APPROVAL		MOUNTING PLATE & SPACER	
CONTRACT NO.		SIZE CASE CODE DWG. NO. B 07M26 41228-502-016	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES OF 3 PLACE DECIMALS ± .01 ARE TO BE USED		SCALE FULL	REV C SHEET 2 of 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
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Process									
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